

Work Order ID 74551

Tuesday, October 04, 2011 9:58:12 AM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID:

Stop



Item Name: GHW Lug

Start Date: 9/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 40.00

Customer:

Reference:

Run Start



Approvals: Process Plan: M.L.J Date: 11/10/04 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3404

Rev C

100

0.00



BAND SAW

0.00

aml 11/10/14

40 Ø

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank: 2.750" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

aml/F.K. 11/10/14

47 Ø

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 Dwg Rev: C Folio Rev:

AA ☐ 2-Debur

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

aml/F.K. 11/10/14

47 Ø

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 9/30/2011 Start Qty: 40.00



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.D 11/10/19

47

0

140

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SP 11-10-19

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/19

mf 11-10-19

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Picklist Print

Page 1

Tuesday, October 04, 2011 9:58:16 AM

Work Order ID: 74551



Parent Item: D3404-1



Parent Item Name: GHW Lug

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: A ☐ 05.09.01 ☐ New issue ☐ KJ/JLM ☐
IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	20.5714	0.2291	9.646316			

304 BAR .750 X 2.50

Location

MAT050

Loc Qty

20.5714

Loc Code

115869

10.8

116765

9.7714

1.604
9.77
K.K. 11/10/18
and 11/10/14

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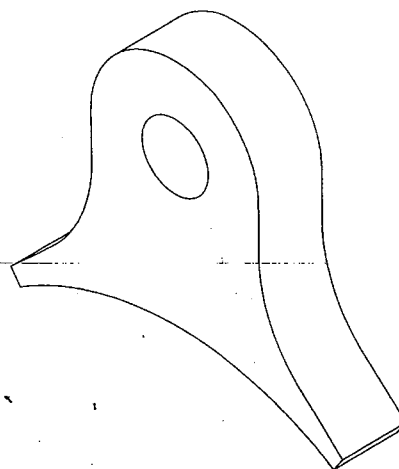
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D3404-1 GHW LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 34551 M.C.J

11/10/04

RELEASED
08/12/04

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.		AJS	08.12.02
B	UPDATE M-SPEC		PH	05.06.14
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>[Signature]</i>	D3404	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	GHW LUG	NTS	
DATE	08.12.02		<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

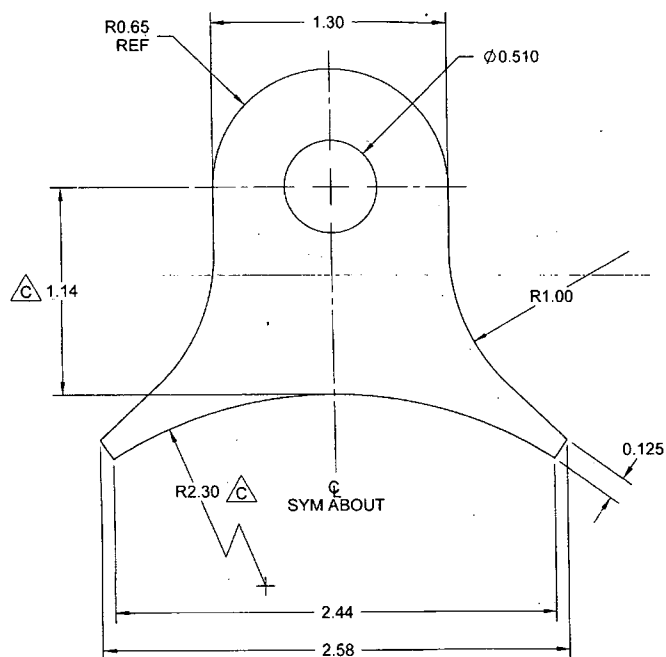
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74851

RELEASED
08/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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